



Farmline Gloss Finish

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Product Description	A high quality, single pack, modified-alkyd gloss finish for agricultural equipment and vehicle exteriors.				
Features & Use	<ul style="list-style-type: none"> • For interior and exterior use on previously painted metal and other substrates • For application to agricultural plant and machinery • Recommended for use with Farmline Primer • For brush, roller or spray application 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	45 ± 2% (varies with colour)				
VOC Content	435 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	30 µm	67 µm	15.0 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 30 microns DFT	+10°C	+23°C	+35°C	
	Dust Free		2½ hr	1½ hr	
	Hard Dry		9 hr	6 hr	
	Overcoating	Minimum	14 hr	12 hr	8 hr
		Maximum	Indefinite (see Product Notes)		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	BS, RAL and manufacturers shades to order				
Product Code	02FAR				
SG	0.98 kg/lit (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				



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Surface Preparation	<ul style="list-style-type: none"> This product is a finish coat and should be applied over an appropriate primer and/or intermediate coat such as Farmline Primer or Farm Oxide Sheen All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination 														
Mixing	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>														
Thinner / cleaner	<p>Axalta Thinner TH400 (formerly called No.3 Thinner)</p>														
Application Conditions	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="464 815 687 891">Method</th> <th data-bbox="687 815 936 891">Airless Spray</th> <th data-bbox="936 815 1182 891">Conventional Spray</th> <th data-bbox="1182 815 1355 891">Brush</th> <th data-bbox="1355 815 1503 891">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="464 891 687 947"></td> <td data-bbox="687 891 936 947">Yes</td> <td data-bbox="936 891 1182 947">Yes</td> <td data-bbox="1182 891 1355 947">Yes</td> <td data-bbox="1355 891 1503 947">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
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<ul style="list-style-type: none"> Brush/roller application is recommended – use as supplied For spray application, first consult the product Safety Data Sheet (SDS) and ensure compliance with all safety requirements Conventional spray: use up to 15% of TH400 Thinner, 50-60psi pressure and 1.4-1.8mm diameter nozzle Airless spray: use up to 10-15% of TH400 Thinner, with 1800-2200psi pressure and 11-15 thou tip (0.28-0.38mm) 															
Product Notes	<ul style="list-style-type: none"> 2 coats of Farmline Gloss are recommended for best results This product is white spirit based, only overcoat with other white spirit based products (with itself is recommended) Overcoating – maximum overcoating time is indefinite if clean and sound, but for best results overcoating within 48 hours (with itself) is recommended (at 20°C) Colours such as bright yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required for solid coverage, relative to only one coat of, say, a grey or red oxide 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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